

Date: Wednesday, 5/31/2006 7:39:45 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 155 BRACKET
Job Number : 27303	
Estimate Number : 11040	
P.O. Number : N/A	Part Number : D28042
This Issue : 5/31/2006 S.O. No. : N/A	Drawing Number : D2804 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 27142	Material : N/A
Written By : <i>SALE COMMENT REPLY</i>	Due Date : 6/18/2006 Qty: 10 Um: Each
Checked & Approved By : <i>KJ 06.05.31</i>	
Comment : Est. A00.11.06 New Issue EC	
Est. B06.05.30 Blanks on wtjetEC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
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Comment: Qty.: 0.7875 f(s)/Unit Total : 7.8750 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: *m100046*
ML 06 06 01 (10)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

ML 06 06 01 (10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

ML 06/06/10 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/06/10 16

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SL 06/06/11 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:39:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 27303

Part Number: D28042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

mf 06/06/10

10

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

JL 06/06/11

(10)

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SAD 06/06/11

(10)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST156*

06/12/6 (10)

1

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Inspection Level 21

SD 06/06/13 (10)

Job Completion



W 06/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27303
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804	Rev: B	Page 1 of 1	

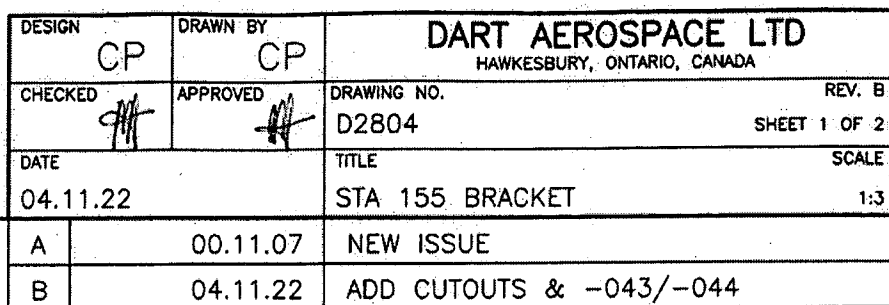
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.127	✓			
0.125	+/-0.010	0.124	✓			
R0.125	+/-0.010	R0.125	✓			
0.250	+/-0.010	0.250	✓			
0.250	+0.000/-0.005	0.250	✓			
0.875	+0.000/-0.001	0.8744	✓			
R0.062	+/-0.010	R0.062	✓			
Ø0.757	+0.005/-0.000	Ø0.759	✓			
R0.625	+/-0.010	R0.625	✓			
12.304	+/-0.005	12.304	✓			
Ø0.507	+0.000/-0.001	Ø0.5065	✓			
0.437	+0.000/-0.001	0.437	✓			
0.608	+0.000/-0.001	0.608	✓			
Ø0.191	+0.005/-0.000	Ø0.191	✓			
1.420	+0.001/-0.001	1.420	✓			
0.250 deep	+/-0.010	0.249	✓			
6.933	+/-0.005	6.933	✓			
7.578	+/-0.005	7.578	✓			
0.500	+/-0.010	0.499	✓			

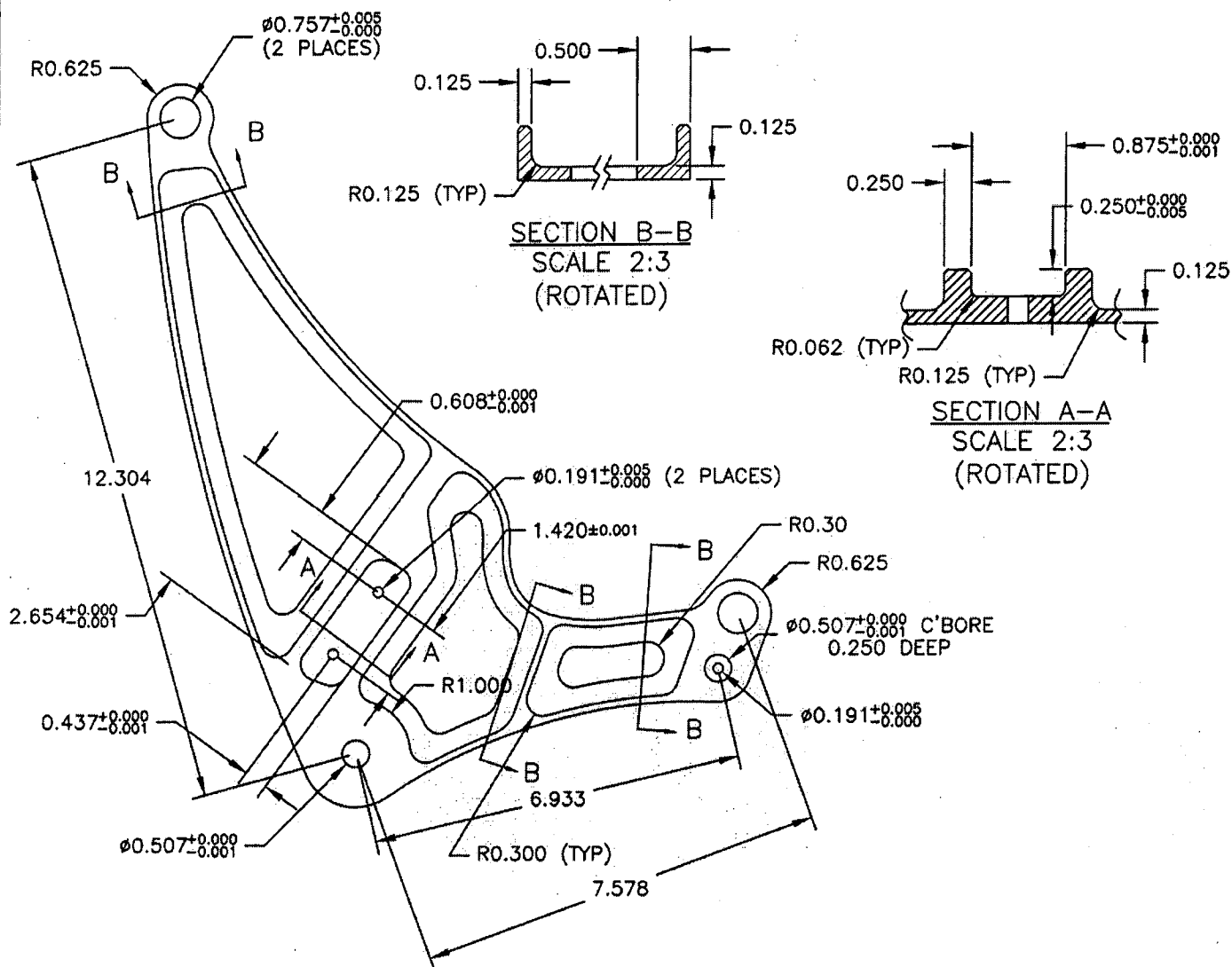
Measured by:	gm	Audited by:	Ep	Prototype Approval:	N/A
Date:	06/06/10	Date:	06/06/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	



RELEASED

05-03-10



1) MACHINE PER DRAWING FILE "D2804.SLDPRT" UNCO
2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

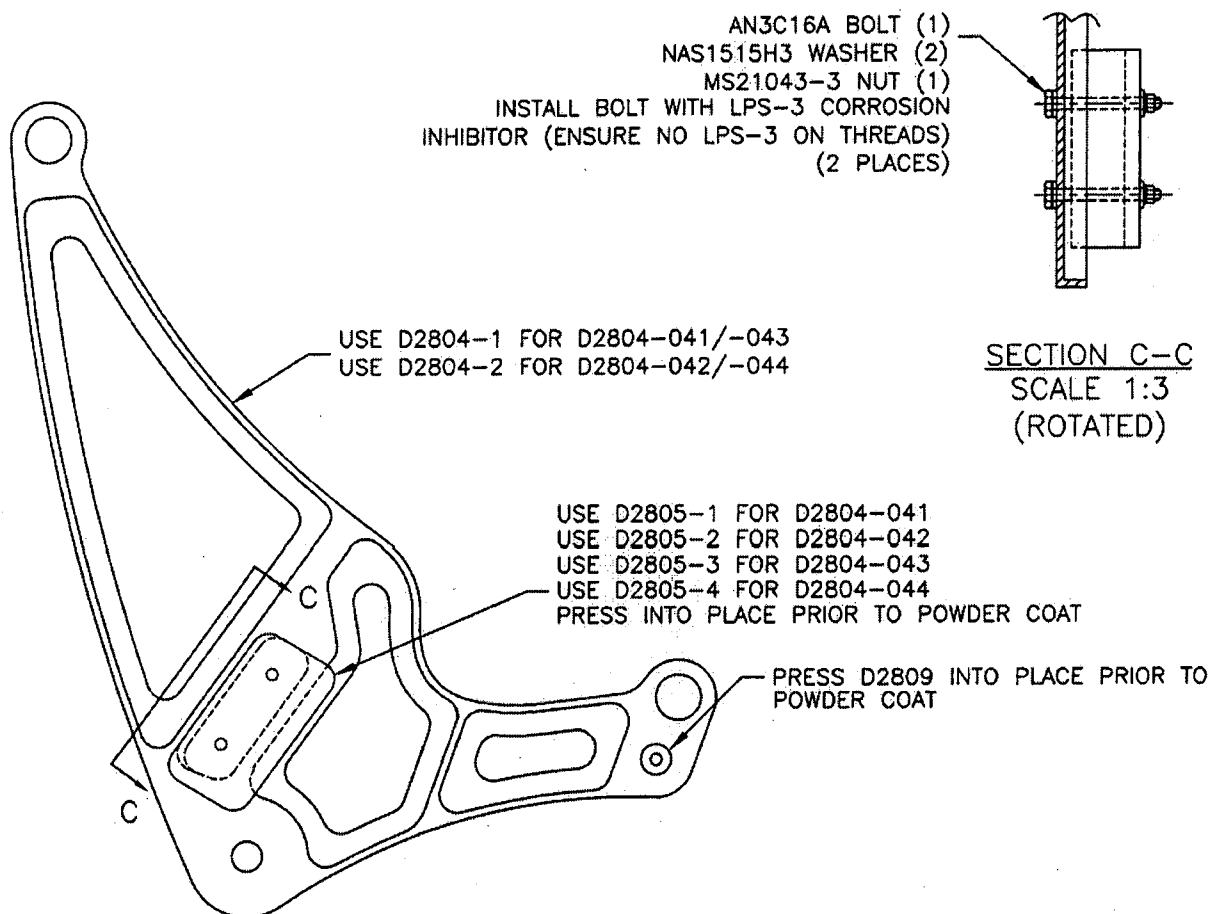
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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804
DATE	04.11.22	TITLE	STA 155 BRACKET	REV. B
				SHEET 2 OF 2
				SCALE 1:3



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D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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